

Ship March 3

Work Order ID 111634-2

111634-2

Page 1

Item ID: D4901-042

Revision ID:

Item Name: Aft Skipaw Assembly, RH

Start Date: 20/01/2014 Start Qty: 15.00

Required Date: 20/02/2014 Req'd Qty: 15.00

Reference:

Approvals:

Process Plan: 

Date: 14-01-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

N900040100

Setup

Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4901

B

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
32
9-89

14/2/24 15

120

0.00

120

Small Fab

Memo

0.00

Small Fab

ASSEMBLE SKIPAW AS PER DWG

DAS
30
9-89

15

14/02/24

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

DAS
27
9-89

14/2/24

15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

January-20-14 10:53:51 AM

Page 1

Work Order ID: 111634-2

111634-2

Parent Item: D4901-042

D4901-042

Parent Item Name: Aft Skipaw Assembly, RH

Start Date: 20/01/2014

Required Date: 20/02/2014

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 13.08.28 NEW ISSUE DD VERF:JLM IPP
REV:C 13.12.09 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4901-2		Manufactured	No			110	Each	0.0000	1	DAS 15			
D4901-2													
Aft Skipaw, RH													
D4904-043		Manufactured	No			110	Each	0.0000	1	DAS 15			
D4904-043													
Aft Wearplate Assy													
AN4-11A		Purchased	No			110	Each	590.0000		60			
AN4-11A													
BOLT													

Location

Loc Qty

Loc Code

FG	20	
120731	20	
ST356	70	
M126073	43	
M126105	27	
ST514	500	
M127290	250	
M127376	250	

M126333

(5)

M126073 35X
M126105 3X

M127290 22X
(6)

MS21042-4 MS21042L4

Purchased

No

110 Each 616.0000

6 90

MS21042-4

Nut

**

DAS
32
9-89

Location

Loc Qty

Loc Code

ST314	616	
119124	592	
m2937	12	
m8182	12	

119124

DQA: _____ Date: _____



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FAULT CATEGORY

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*Picklist Print

January-20-14 10:53:51 AM

Work Order ID: 111634-2

111634-2

Parent Item: D4901-042

D4901-042

Parent Item Name: Aft Skipaw Assembly, RH

Start Date: 20/01/2014

Required Date: 20/02/2014

Start Qty: 15.00

Required Qty: 15.00

NAS1149F0463P

Purchased

No

110

Each

2,295.000

6

90

DAS

NAS1149F0463P

**

32

Washer

~~9.89~~

Location

Loc Qty

Loc Code

ST295

295

124859

295

ST510a

2000

m123374

400

m127832

1600

124809

14/2/24 (15)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

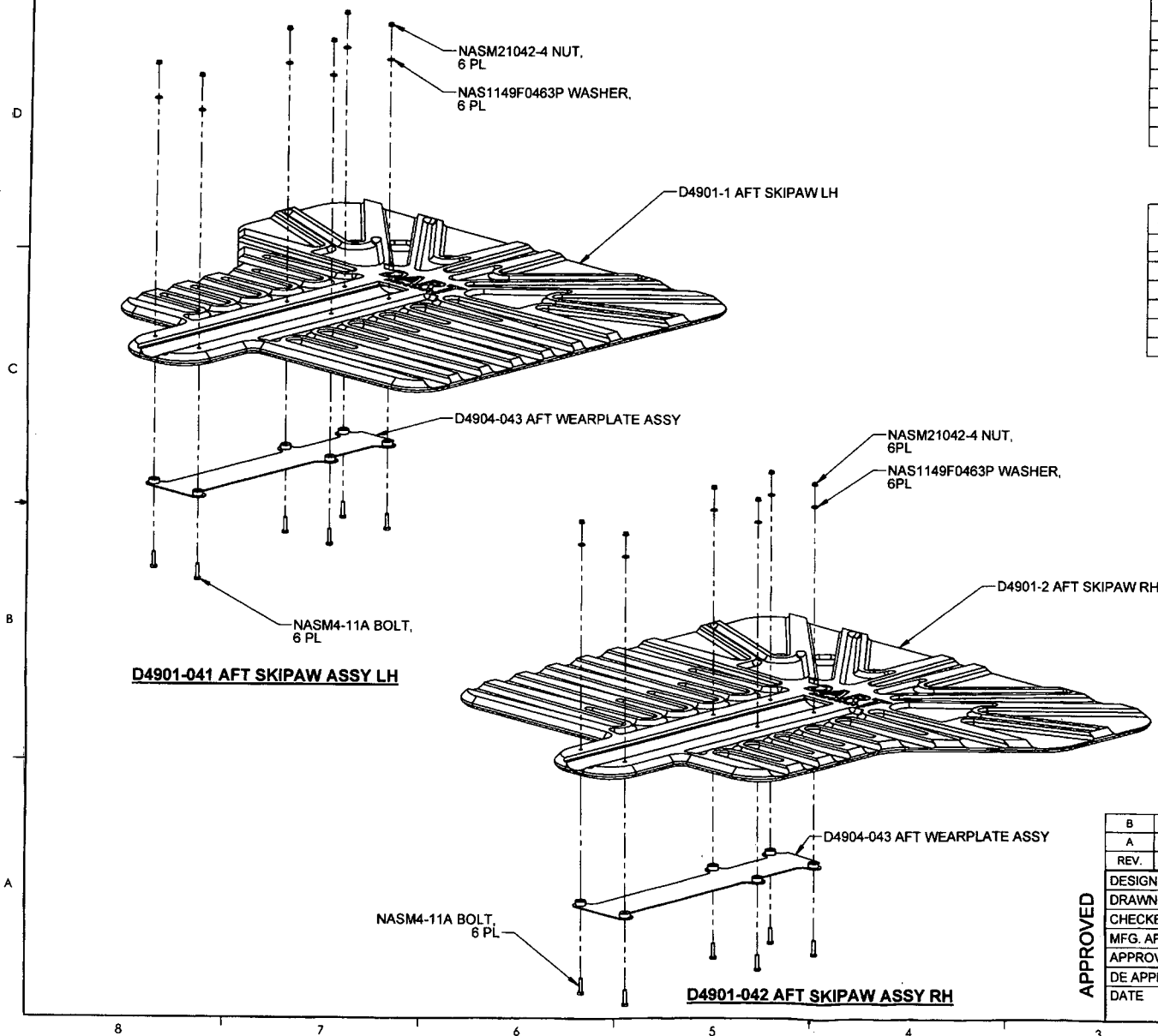
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8 7 6 5 4 3 2 1



ITEM	QTY	P/N	DESCRIPTION
	X	D4901-041	AFT SKIPAW ASSY LH
1	1	D4901-1	AFT SKIPAW LH
2	1	D4904-043	AFT WEARPLATE ASSY
3	6	NASM4-11A	BOLT
4	6	NASM21042-4	NUT
5	6	NAS1149F0463P	WASHER (AN960-416)

ITEM	QTY	P/N	DESCRIPTION
	X	D4901-042	AFT SKIPAW ASSY RH
1	1	D4901-2	AFT SKIPAW RH
2	1	D4904-043	AFT WEARPLATE ASSY
3	6	NASM4-11A	BOLT
4	6	NASM21042-4	NUT
5	6	NAS1149F0463P	WASHER (AN960-416)

111634-2 M
14-01-20

RELEASED
2013-12-05

B	REMOVE POCKET DETAIL FROM -1/-2 (SH 2, 3).	DB	13.11.20
A	NEW RELEASE	DB	13.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4901	SHEET 1 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	AFT SKIPAW	NTS
DATE	13.11.22	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

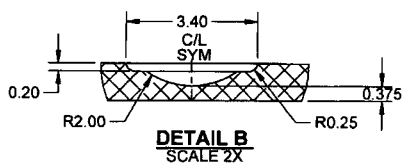
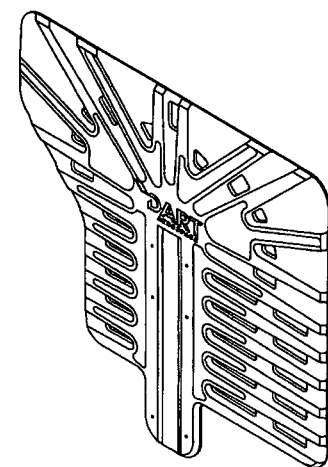
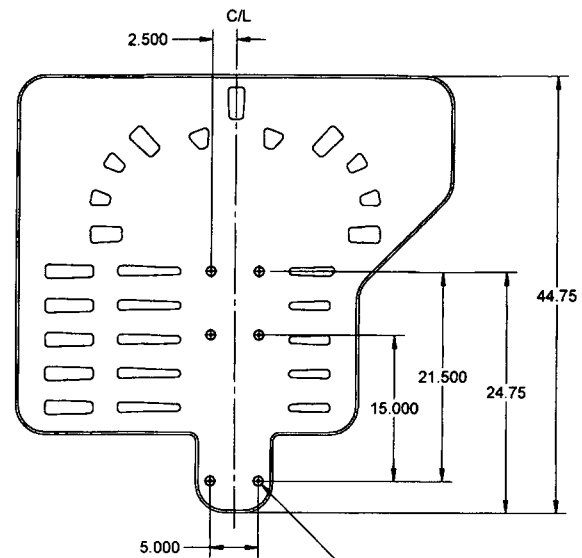
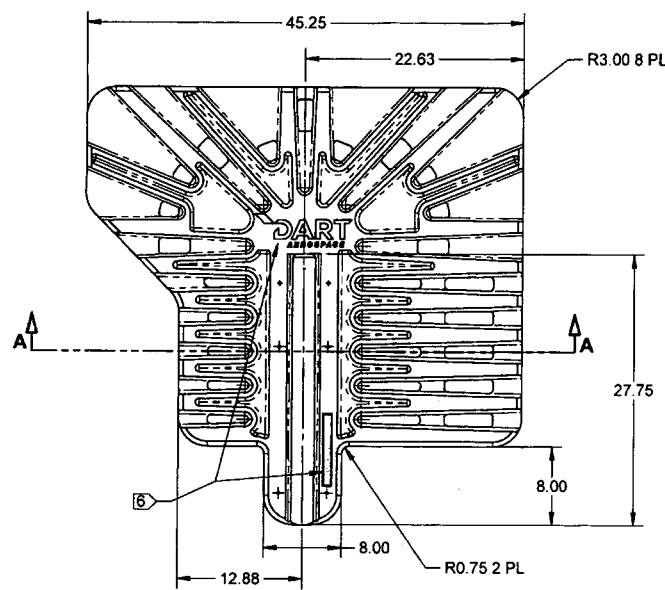
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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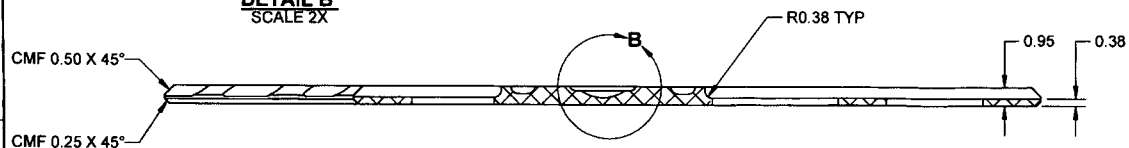
8 7 6 5 4 3 2 1



DETAIL B
SCALE 2X

D4901-1 AFT SKIPAW LH

6X ϕ 0.266 THRU ALL
CBORE ϕ 0.950 X 0.50 DP
CSK ϕ 1.00 X 90°, NEAR SIDE



SECTION A-A
SCALE 2X

NOTES:

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMWB100
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE WITH P/N "D4901-1" AND B/N USING 0.13 HIGH LETTERS TO MAX. DEPTH OF 0.010". AS PER QSI 044, METHOD 6.3
ENGRAVE "DART AEROSPACE" LOGO AS SHOWN, MAX DEPTH 0.030" WITH MIN. RAD. OF 0.010"
- 7) WEIGHT: 60.99 lbs
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4901-1-B.IGES

APPROVED

DESIGN	DB
DRAWN	DB
CHECKED	AP
MFG. APPR.	JLM
APPROVED	MP
DE APPR.	DS
DATE	13.11.22

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4901	REV. B SHEET 2 OF 3
TITLE AFT SKIPAW	SCALE NTS
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RELEASED
2013-12-05

8 7 6 5 4 3 2 1

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